

Work Order ID 154594

Thursday, December 15, 2016 1:33:57 PM

154594

Ship JAN 6

Page 1

Item ID: D3822-3KIV Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Vertical Tunnel, Aft Center, Ivory
Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:

Reference:

DAS

21

9-89

Approvals: Process Plan: _____ Date: DEC 15 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3822	Rev C								DAS 07 9-89
100		0.00							
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								16/12/20
105		0.00							DAS 07 9-89
105	Dry Material								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per OSI022 KYDEX								16/13/20
	Temp: 150 deg. F								
	Time IN: 5:00 PM								
	Time OUT: 6:00 AM								

DEC 20 2016

P...

16/12/2

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[illegible]

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Item ID: D3822-3KIV Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.02							
Quality Control									

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JAN 06 2017

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JAN 03 2017

Picklist Print

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Work Order ID: 154594

154594

Parent Item: D3822-3KIV

D3822-3KIV

Parent Item Name: Vertical Tunnel, Aft Center, Ivory

Start Date: 12/12/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	1,738.890	5.25	5.252626			DAS 07 9-89

MKYD6185S 080-P3-62015

Kydex Ivory (52"x96"-.080)

Location	Loc Qty	Loc Code
SHED	728	
m129761	347	
m130671	381	
therm	1010.89	
121755	13.44	
124462	997.45	

5.76.58 P4

DART AEROSPACE LTD	Work Order:	154594
Description: Vertical Tunnel, Aft Center	Part Number:	D3822-3KIV/KGY
Inspection Dwg: D3822 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DAS 07 9-89	Date:	16/12/20
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.066"	✓			
0.020	Min	0.059"	✓			
0.035	Min	0.050"	✓			
0.4	Min	0.42"	✓			

Measured by:	DAS 07 9-89	Date:	16/12/21
Audited by:	9 9-89	Date:	16-12-22
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

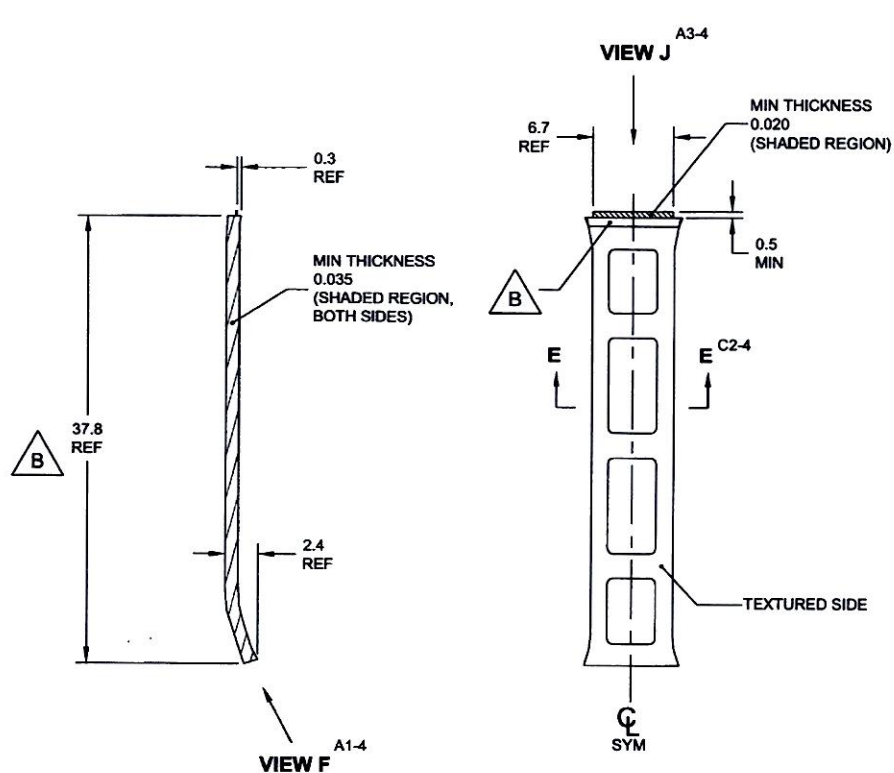
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D

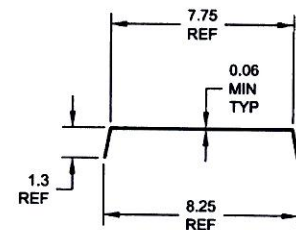
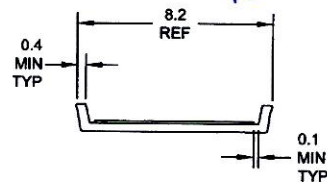
C

B

A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154594 MW
16-15



D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

VIEW J
SCALE 2X

RELEASED
09/05/22 MW

VIEW F
SCALE 2X
(ROTATED 90° CW)

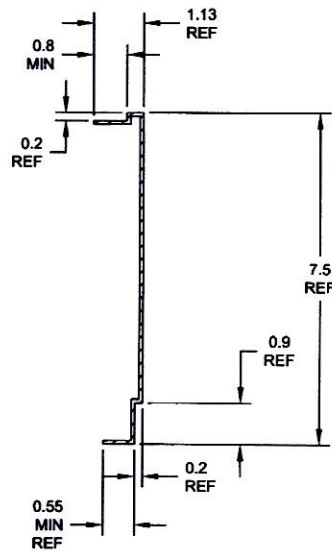
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

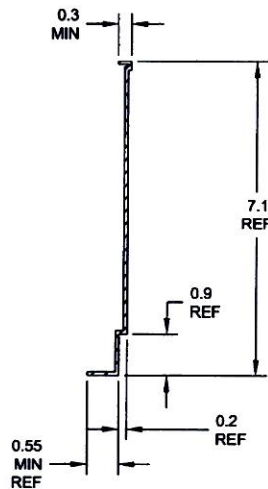
PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D3822	SHEET 4 OF 6
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	VERTICAL TUNNEL (BELL 206 A/B)	NTS
DE APPR.	RF	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	09.05.05	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

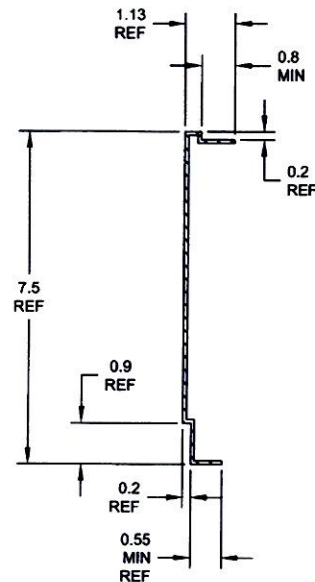
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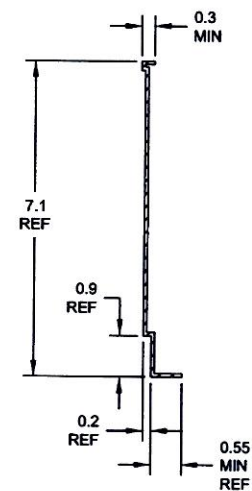
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

RELEASED
09/05/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3822	SHEET 3 OF 6
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